

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004703**Date Inspected:** 22-Nov-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Chih Chien**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

The Caltrans (CT) Quality Assurance (QA) Inspector Charlie Franco was present at the time requested to randomly observe welding and associated operations being performed for the Tower and Orthotropic Box Girders (OBG).

**OBG Bay 4:**

The QA Inspector randomly observed ZPMC Non-Destructive Testing (NDT) Technician Wang Wei, utilizing the Magnetic Particle Testing (MT) Method to perform a final MT examination of the cover pass of the fillet welds on Bottom Plate Sub-Assemblies BP42A/Yellow Tag 001722 WJ's 8CW-BP042-001-007 through 018 and 037 through 048; BP176A/Yellow Tag 001719 WJ's 8BW-BP176-001-007 through 018; and Side Plate SP459A/Yellow Tag 001720 WJ's 8CE-SP459-001-011 through 020. There appeared to be no indications and ZPMC QC accepted all welds on the above listed Sub-Assemblies.

The QA Inspector performed a 100% final Visual Testing (VT) and 10% MT verification on the cover pass of the fillet welds on Bottom Plate Sub-Assemblies BP42A/Yellow Tag 001722 WJ's 8CW-BP042-001-007 through 018 and 037 through 048(Green Tag 001733), BP176A/Yellow Tag 001719 WJ's 8BW-BP176-001-007 through 018(Green Tag 001749) and Side Plate SP459A/Yellow Tag 001720 WJ's 8CE-SP459-001-011 through 020. (Green Tag 001749). There appeared to be no indications the QA Inspector accepted all welds on the above listed Sub-Assemblies. The QA Inspector also performed a 100% final VT verification of all the fillet welds on Bottom Plate BP177A/Yellow Tag 001721 WJ's 8CE-D6-BP177-001-007 through 018 and 037 through 048(Green Tag 001730). Final QA MT had been previously performed and accepted by QA Inspector Lot Number B49 on

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## WELDING INSPECTION REPORT

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11-21-08. The attached photographs provide additional detail.



### Summary of Conversations:

As noted in the above body of this report.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Joshua Ishibashi, 13764710411, who represents the Office of Structural Materials for your project.

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**Inspected By:** Franco, Charlie

Quality Assurance Inspector

**Reviewed By:** Wright, Mark

QA Reviewer

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